

**LUPOY EC5000A**

(PC+ABS)

LG Chem

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ASTM Data</b>			
Melt Flow Index, MFI	9	g/10min	ASTM D 1238
Temperature	250	°C	-
Load	2.16	kg	-
Mold Shrinkage, MD	0.005	mm/mm	ASTM D 955
<b>Mechanical properties</b>			
<b>ASTM Data</b>			
Tensile Strength at Yield	54.9	MPa	ASTM D 638
Elongation at Break	80	%	ASTM D 638
Flexural Modulus	3139	MPa	ASTM D 790
Flexural Strength	94.2	MPa	ASTM D 790
Izod Impact notched, 1/8 in	471	J/m	ASTM D 256
<b>Thermal properties</b>			
<b>ASTM Data</b>			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	1.5	mm	-
DTUL @ 66 psi	97	°C	ASTM D 648
<b>Electrical properties</b>			
<b>ISO Data</b>			
Surface resistivity	1E11	Ohm	IEC 62631-3-2
<b>Other properties</b>			
Density	1180	kg/m <sup>3</sup>	ASTM D 792
<b>Processing Recommendation Injection Molding</b>			
Pre-drying - Temperature	60 - 80	°C	-
Pre-drying - Time	4 - 6	h	-
Processing humidity	≤0.02	%	-
Melt temperature	230 - 260	°C	-
Mold temperature	50 - 70	°C	-
Zone 1	210 - 240	°C	-
Zone 2	215 - 250	°C	-
Zone 3	225 - 260	°C	-
Nozzle temperature	220 - 250	°C	-
Screw speed	40 - 70	rpm	-
Back pressure	1 - 4	MPa	-

**Characteristics****Processing**

Injection Molding

**Applications**

Electrical and Electronical, General Purpose

**Special Characteristics**

Anti-static

**Regional Availability**

North America, Europe, Asia Pacific, South and Central America